

Date: Thursday, 22/01/2009 7:59:00 AM
User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LOWER BLADE SUPPORT AND COVER ASSEMBLY
Job Number : 45035 - 2
Estimate Number : 13521
P.O. Number :
This Issue : 22/01/2009 S.O. No. :
Prsht Rev. : NC Part Number : PB674300123
First Issue : 11 Type : SMALL / MED FAB Drawing Number : B6743001 P.10
Previous Run : 43057 Drawing Revision : B1
Material :
Written By : Due Date : 28/01/2009 Qty: 18 Um: Each
Checked & Approved By : MF 09-01-22
Comment : Est Rev:A 08-07-25 new issue DD verified by:ec

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MS27039110 Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 144.0000 Each(s)
Screw
batch: m109031

MF 09-03-05

2.0 NAS1149F0316P WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 144.0000 Each(s)
WASHER
batch: m109053 x 100 + 109031 x 44

MF 09-03-05

3.0 PB674300179 Lower Blade Support Ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total: 18.0000 Each(s)
Lower Blade Support Ass'y
batch: B45424 x 16, B42999 x

MF 09-03-05

4.0 PB674300183 PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total: 18.0000 Each(s)
PB67-43001-83
batch: B41516 x 2, 45008 x 16

MF 09-03-05

5.0 PB6743001181 Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 18.0000 Each(s)
Cover Plate
batch: 41482 x 10, B40033 x 4

MF 09-03-05

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOWER BLADE SUPPORT AND COVER ASSEMBLY

Job Number: 45035

Part Number: PB674300123

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



FL 02/03/06 (14)



(14)

Comment: Assemble as per dwg PB67-43001

FL

02/03/06

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

D 02/03/06 (14)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FL 03/06 (14)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



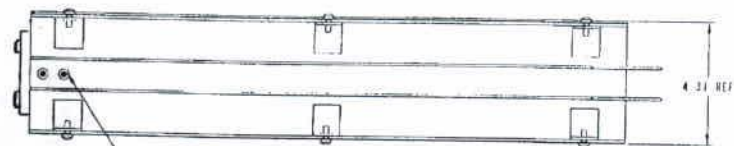
Comment: FINAL INSPECTION/W/O RELEASE

D 02/03/06 (14)

Job Completion

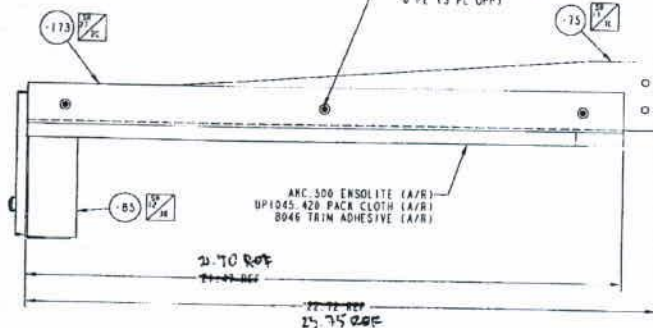


mf 09-03-06

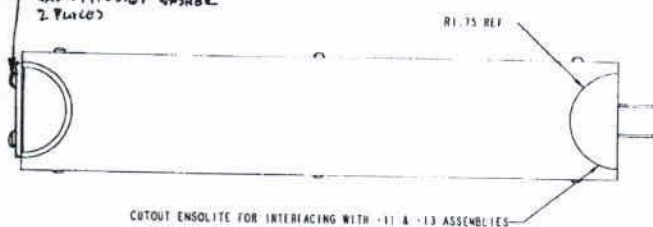


Ø .250 THRU -173
MATCH DRILL WITH HOLE
PATTERN OF -75
MS27039 1-10 SCREW
NAS1149F0316P WASHER
2 PLACES

MATCH DRILL COVER TO HOLES IN
ANGLE BRACKETS. ATTACH USING
MS27039 1-10 SCREW
NAS1149F0316P WASHER
6 PL (3 PL OPP)



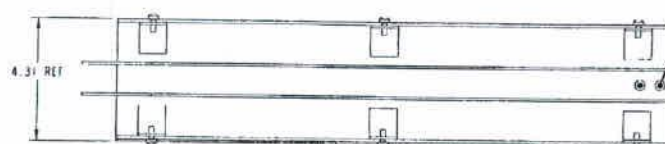
MS27039-1-10 SCREW
NAS1149F0316P WASHER
2 PLACES



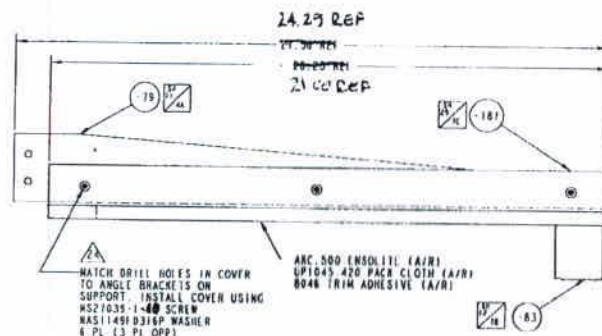
CUTOUT ENSOLITE FOR INTERFACING WITH -11 & -13 ASSEMBLIES

② -21 UPPER BLADE SUPPORT AND COVER ASSEMBLY

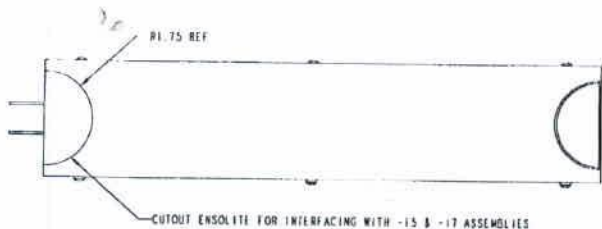
SCALE 0.500



Ø .250 THRU -181
MATCH DRILL -181 WITH
EXISTING HOLE PATTERN
OF -79
MS27039 1-10 SCREW
NAS1149F0316P WASHER
2 PLACES



MATCH DRILL HOLES IN COVER
TO ANGLE BRACKETS ON
SUPPORT. INSTALL COVER USING
MS27039-1-10 SCREW
NAS1149F0316P WASHER
6 PL (3 PL OPP)



CUTOUT ENSOLITE FOR INTERFACING WITH -15 & -17 ASSEMBLIES

② -23 LOWER BLADE SUPPORT AND COVER ASSEMBLY

SCALE 0.500

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ORIGINAL